

Work Order ID 84563

84563

Page 1

May-16-12 12:25:28 PM

Item ID: D2734 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step End Plate
 Start Date: 16/05/2012 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 23/05/2012 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/05/14 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr					(75)			
D2734	Rev C								

100 0.00
100 FLOW WATER JET
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D 2734
 Dwg Rev: C
 Prog Rev: C
 2-Deburr if necessary
 110 0.00
110 QC2- Inspect parts off machine FAI/FAIB
 QC Memo 0.00
 Quality Control
 120 0.00
120 QC8- Inspect parts - second check
 QC Memo 0.00
 Quality Control

countes
 (X75)

12/05/17

12-5-16

12-5-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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May-16-12 12:25:28 PM

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Page 2

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab					(75)			Sp 12/05/22
Small Fab	Memo	0.00							
Small Fab	Form as per drawing D2734								
140		0.00							
140	QC5- Inspect part completeness to step on W/O					(75)			correct 12/05/22
QC	Memo	0.00							
Quality Control									
150		0.00							
150	Identify as per dwg & Stock Location: <u>W104</u>					75	0		12.05.23
Packaging	Memo	0.00							
Packaging	*** STOCK IN STEP CELL***								

Dart Aerospace Ltd

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Page 3

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Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Step End Plate

Stop ***NS2***

Start Date: 16/05/2012 Start Qty: 40.00

40

Cust Item ID:

Required Date: 23/05/2012 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

12/5/29 *[Signature]*
160 12/05/28

W/O:		WORK ORDER CHANGES					
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Picklist Print

May-16-12 12:25:31 PM

Page 1

Work Order ID: 84563

84563

Parent Item: D2734

D2734

Parent Item Name: Step End Plate

Start Date: 16/05/2012

Required Date: 23/05/2012

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP: D01.06.08Removed DeburrEC

IPP Rev:E 07-12-18 RevC as per dwg ECN1048 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.063		Purchased	No			100	sf	61.8526	0.0625	2.631579		S,	
M5052H32S 063										**			B12-5-16
5052-H32 .063 Sheet													

Location

MAT022

114322

120603

Loc Qty

61.852632

12.852632

49

Loc Code

120603

(15)

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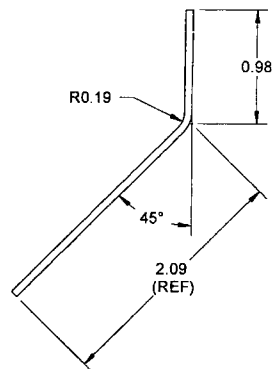
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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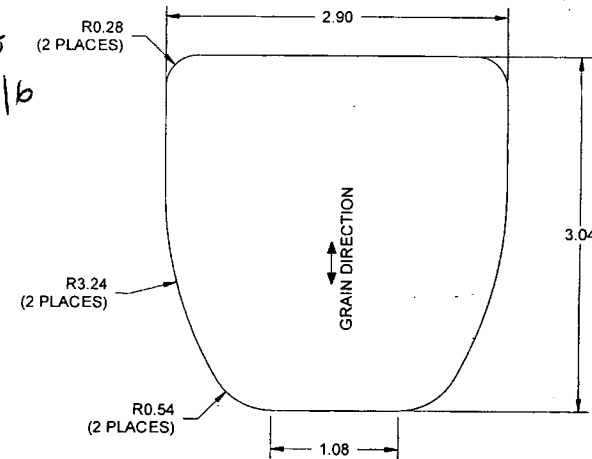
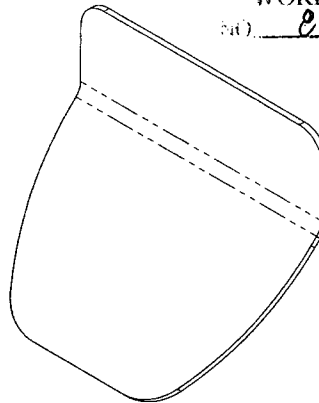
NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

84563 MJS
12/05/16



D2734 END PLATE



D2734 FLAT PATTERN

RELEASED
07.12.16

NOTES:

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET
PER AMS-QQ-A-250/8 OR AMS 4016
(REF. DART SPEC. M5052H32S.063) OR
6061-T6 (OR 6061-T6) ALUMINUM SHEET
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.05 lbs

C	ADD GRAIN DIRECTION NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.20
B	0.976 WAS 1.016, 2.097 WAS 2.137	KE	98.10.05
A	NEW ISSUE	KE	97.12.10
REV.	DESCRIPTION	BY	DATE
DESIGN	KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KE		
CHECKED	KE	DRAWING NO.	REV. C
MFG. APPR.	KE	D2734	SHEET 1 OF 1
APPROVED	KE	TITLE	SCALE
DE APPR.	KE	END PLATE	1:1
DATE	07.11.20	COPYRIGHT © 1997 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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